

Work Order ID 84225

May-08-12 8:40:22 AM

84225

Page 1

Item ID: D3126-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 08/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 24/05/08 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3126

Rev A1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3126 Dwg Rev: A1 Prog Rev: A1 2-
Deburr if necessary

34.037

4 0 Jm
12-5-28

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 0 Jm
12-5-28

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

4 0 N 12-05-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

May-08-12 8:40:22 AM

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket

Stop *NS2*

Start Date: 08/05/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00

130

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Deburr if necessary Form on CNC brake as per D3126 using Jig
D3126T1 Identify as D3126-3 Scribe Dart P/N as shown on Dwg D3126

140

QC5- Inspect part completeness to step on W/O

0.00

140

Memo

0.00

QC

Quality Control

150

Identify as per dwg & Stock Location: 5527

0.00

150

Memo

0.00

Packaging

Packaging

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Work Order ID 84225

84225

Page 3

Item ID: D3126-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 08/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/5/30

12-05-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

May-08-12 8:40:25 AM

Page 1

Work Order ID: 84225

84225

Parent Item: D3126-3

D3126-3

Parent Item Name: Bracket

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A03.01.15New issueKJ/RF
IPP Rev:B Now On Water Jet 06-08-14 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S22GA | | Purchased | | No | | 100 | sf | 116.8600 | 0.0589 | 0.248 | | | |

M304S22GA

304/316 .032 Sheet

**

Location

Loc Qty

Loc Code

MAT020

116.86

118271

11.88

120866

104.98

120866

JM
12-5-28

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NOTE: Date & initial all entries

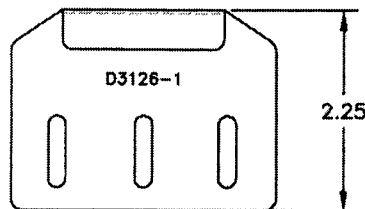
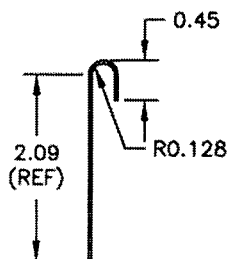
DART

SUPERCEDED BY

Rev. B 04.11.24

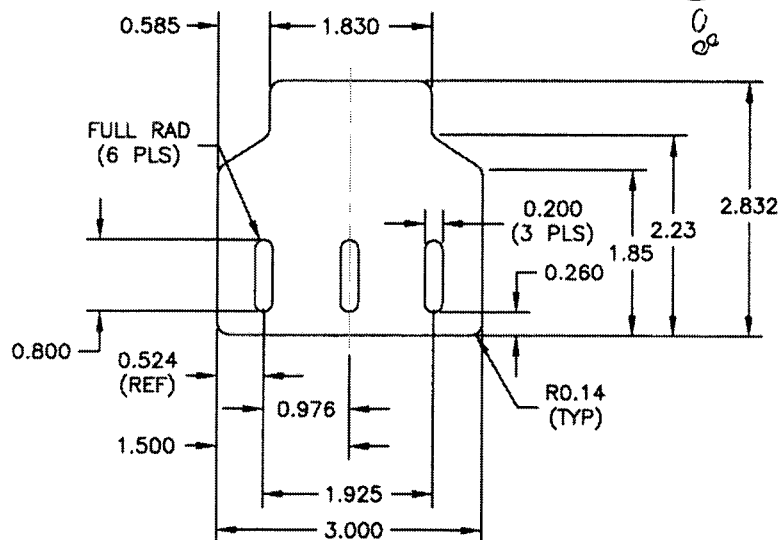


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|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3126 | REV. A SHEET 1 OF 3 |
| DATE 02.04.17 | | TITLE BRACKET | SCALE 1:2 |
| A | 02.04.17 | NEW ISSUE | |
| AI | 02.09.23 | ADD "ANNEALED" SPEC | |

RELEASED
02.05.27

D3126-1 BRACKET
REPLACES PREMIER P/N B30-23000-265

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 04225 MJT
12/05/08



D3126-1 BRACKET FLAT PATTERN

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-1 AS SHOWN

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

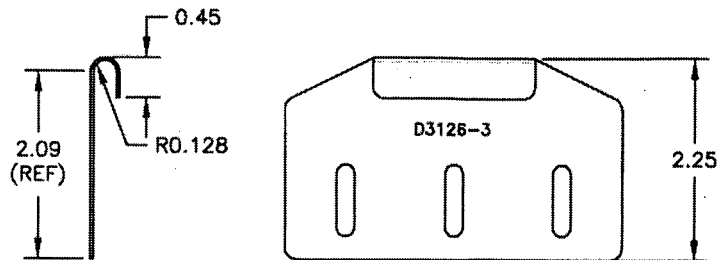
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NOTE: Date & initial all entries

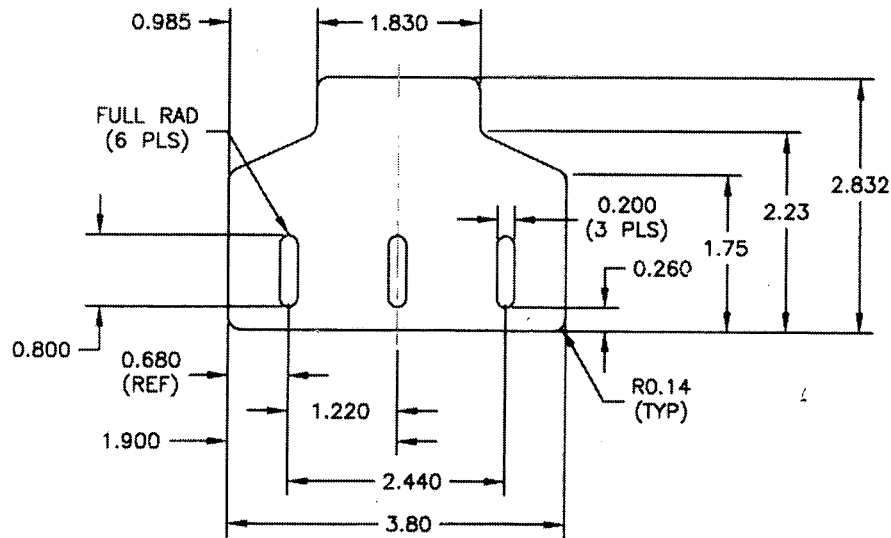


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| DESIGN # | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3126 | REV. A SHEET 2 OF 3 |
| DATE 02.04.17 | | TITLE BRACKET | SCALE 1:2 |

RELEASED
02.05.27



D3126-3 BRACKET
REPLACES PREMIER P/N B30-23000-267



D3126-3 BRACKET FLAT PATTERN

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 5) SCRIBE DART P/N D3126-3 AS SHOWN

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

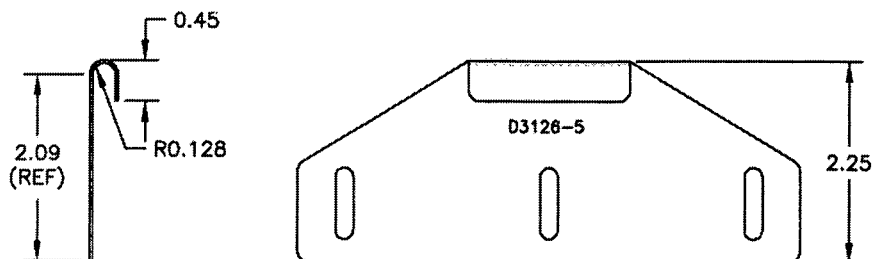
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NOTE: Date & initial all entries

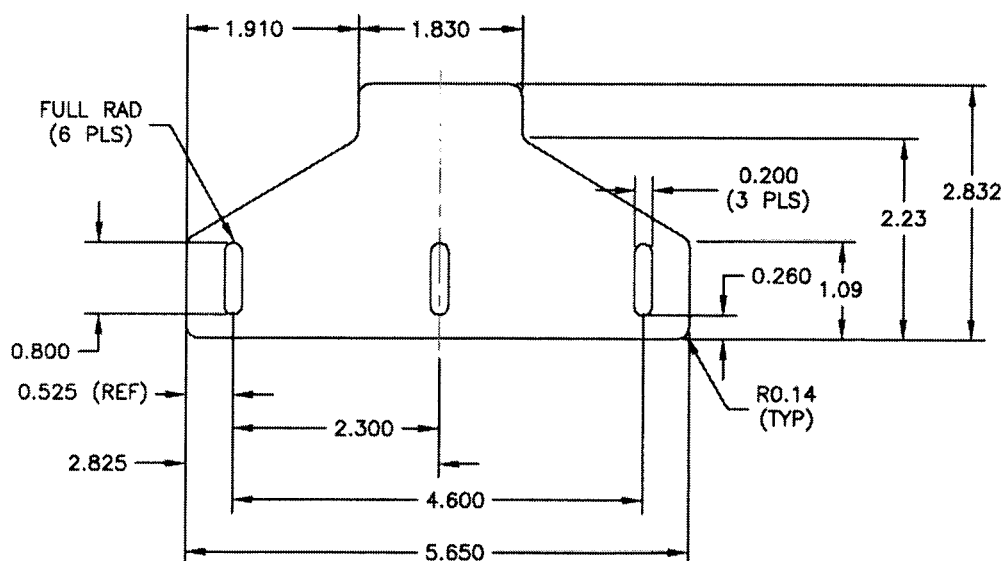


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| DESIGN # | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3126 | REV. A SHEET 3 OF 3 |
| DATE 02.04.17 | | TITLE BRACKET | SCALE 1:2 |

RELEASED
02.05.27



D3126-5 BRACKET
REPLACES PREMIER P/N B30-23000-269



D3126-5 BRACKET FLAT PATTERN

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-5 AS SHOWN

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